

Work Order ID 131346

April-02-15 12:57:26 PM

131346

ASAP

Page 1

Item ID: D3859-041

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate

Start Date: 4/02/15

Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/10/15

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 150402

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3859

B

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3859-1

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

16

02/15/04/05

16

02/15/04/05

16

DAS
38
9-89

APR 06 2015

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Item ID: D3859-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate
 Start Date: 4/02/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/10/15 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Large Fab	0.00							
130									
Large Fab	Memo	0.00							
Large Fab	1-Weld D4379-5 cups as per dwg D3859 A/R 316L stainless steel rod Batch: <u>M123823</u>								
	2-Weld hard facing as per Dwg D3859 A/R 2059B Hard Coat rod Batch: <u>M129694</u>								
	*****use DT9462 for welding*****								
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
140									
QC	Memo	0.00							
Quality Control									

88 15-06-09 MAL

8 15-6-9 DAS 50 0-89

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Item ID: D3859-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate
 Start Date: 4/02/15 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 4/10/15 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>Ship</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

ME 15-6-9

MLS JUN 10 2015

ME
15-6-9

Picklist Print

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Work Order ID: 131346

131346

Parent Item: D3859-041

D3859-041

Parent Item Name: Wearplate

Start Date: 4/02/15

Required Date: 4/10/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC
14.04.30 as per dwg rev.b DD verified by:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4379-5		Manufactured	No			130	Each	132.0000	6	72			

D4379-5

Wearplate Cup

15-06-04
JLM

Location	Loc Qty	Loc Code
ST103	4	
126889	4	
WA001 133126	128	
129499	100	
129613	28	

M304S16GA

Purchased

No

100

sf

454.8176

0.85

11

M304S16GA

304/316 Sheet .063

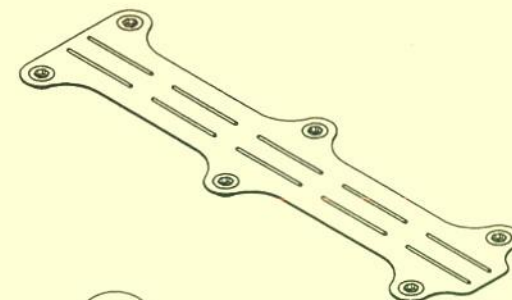
15/04/05

Location	Loc Qty	Loc Code
MAT019	454.8176	
m131384	195.8176	
m131503	259	

13.8

ITEM NO.	QTY. -041	P/N	DESCRIPTION
	X	D3859-041	WEARPLATE
1	1	D3859-1	WEARPLATE
2	6	D4379-5	WEARPLATE CUP

△ B



131346 MJS
15-04-02

2059B HARDCOAT
10 PL

0.06
TO
0.13
HIGH

CL
SYM

0.38

1.0
TYP

3.1
TYP

1.50
REF

1.00

HARDCOAT WELD
SURFACING
REF

6 PL
1/32

6

D3859-1 WEARPLATE (1)

INSTALL D4379-5 FLUSH
WITH THIS SURFACE
TYP

D4379-5 WEARPLATE CUP (6) △ B

D3859-041 WEARPLATE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

RELEASED

2014 MAR 29

ECN 14-544

APPROVED

B	D4379-5 CUP WAS D3009-3 CUP	DB	14.03.05
A	NEW ISSUE	HS	09.01.26
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	DB		
CHECKED	AP		
MFG. APPR.	DD		
APPROVED	MP		
DE APPR.	DS		
DATE	14.03.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

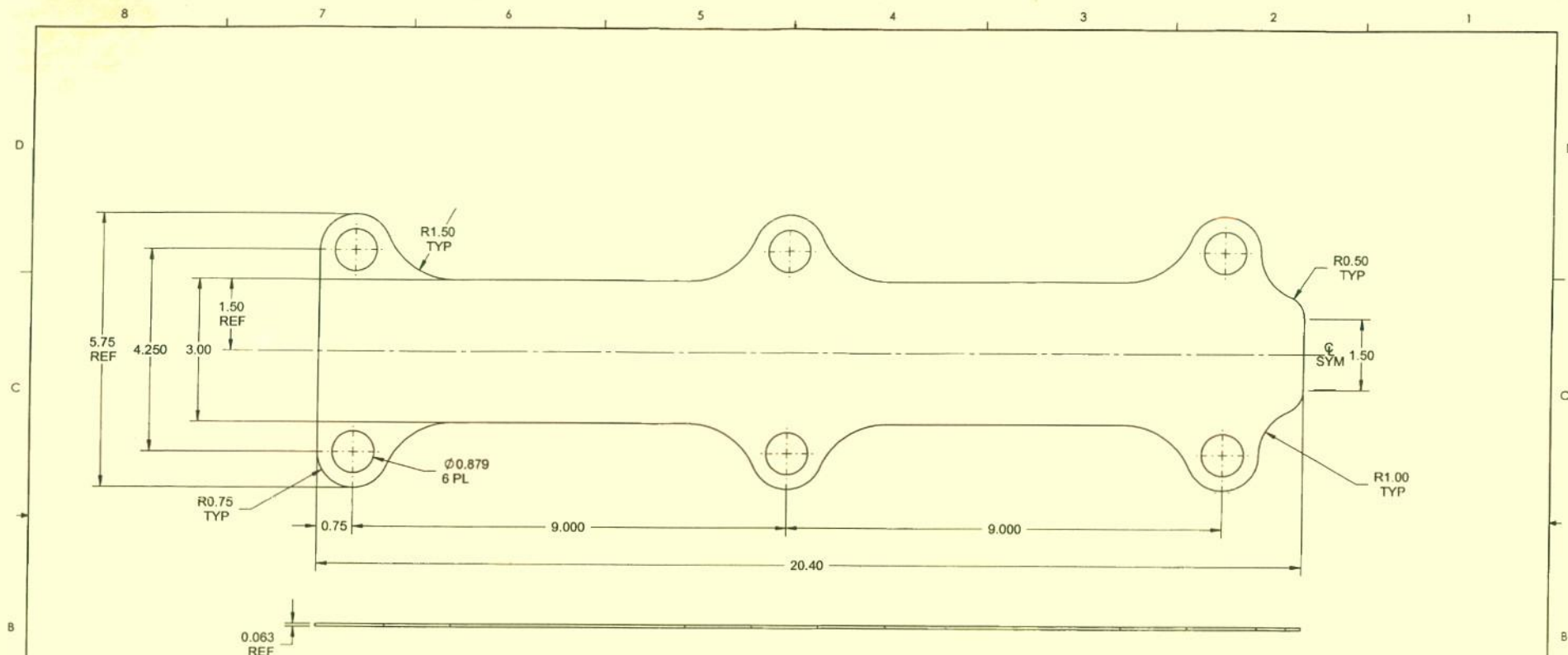
DRAWING NO.
D3859

REV. B
SHEET 1 OF 2

TITLE
WEARPLATE

SCALE
NTS

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D3859-1 WEARPLATE

RELEASED
2014 MAR 29 *up*

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK),
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs

APPROVED

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	DD	D3859	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DB	WEARPLATE	NTS
DATE	14.03.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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